

WHAT IS CLAIMED IS

1. A method of manufacturing a heat exchanger tube obtaining tubes of predetermined lengths by a step of forming cutting grooves in advance in a strip material at predetermined intervals, a step of rolling the strip material into a tubular shape to form a continuous tube, and a step of separating the continuous tubes at the cutting grooves by applying external force to parts of the continuous tube, wherein, when forming the cutting grooves in advance in the strip material, thin parts and thick parts are formed in the cutting grooves.

2. A method of manufacturing a heat exchanger tube as set forth in claim 1, further comprising, when forming said cutting grooves in advance in said strip material, forming said thick parts at parts of said cutting grooves where stress concentrates in said step of forming said continuous tube from said strip material.

3. A method of manufacturing a heat exchanger tube as set forth in claim 2, further comprising forming said thick parts at parts of said cutting grooves formed at the two side edge parts of said strip material.

4. A method of manufacturing a heat exchanger tube as set forth in claim 2, further comprising forming said thick parts at parts of said cutting grooves formed at parts of said strip material which will be bent to form the two side edges of the tube.

5. A method of manufacturing a heat exchanger tube as set forth in claim 1, further comprising, when forming said cutting grooves in advance in said strip material, forming said thick parts at parts of said cutting grooves hard to deform when external force is applied in said step of separating said continuous tube.

6. A method of manufacturing a heat exchanger tube as set forth in claim 1, further comprising forming said thin parts at parts of said cutting grooves formed at parts of said strip material ending up becoming belly surfaces of the tubes.



7. A method of manufacturing a heat exchanger tube as set forth in claim 1, further comprising applying external force to parts of said continuous tube to separate said continuous tube at said cutting grooves by passing said continuous tube between at least four rollers arranged in a zigzag configuration, divided into two groups, and set to a distance between the two groups of rollers slightly smaller than the short diameter of said continuous tube so as to make said continuous tube undulate between said two groups of rollers.

8. A method of manufacturing a heat exchanger tube obtaining tubes of predetermined lengths by a step of forming cutting grooves in advance in a strip material at predetermined intervals, a step of rolling the strip material into a tubular shape to form a continuous tube, and a step of separating the continuous tubes at the cutting grooves by applying external force to parts of the continuous tube, wherein, when forming the cutting grooves in advance in the strip material, partial differences are provided at the thickness of the strip material remaining at the cutting grooves.

9. An apparatus for manufacturing a heat exchanger tube which applies external force at parts of a continuous tube formed with cutting grooves in advance at predetermined intervals so as to separate the continuous tube at the cutting grooves by providing at least four rollers arranged in a zigzag configuration, the rollers being divided into two groups and the distance between the two groups of rollers being set slightly smaller than the short diameter of the continuous tube, and by passing the continuous tube between the two groups of rollers.

10. A heat exchanger tube manufactured by cutting into predetermined lengths a continuous tube having a flat cross-sectional shape formed by bending a strip material, wherein the ends after cutting are formed with first parts thinner than parts other than the ends and with second parts thicker than the first parts and



thinner than parts other than the ends.

11. A heat exchanger tube as set forth in claim 10, wherein said first parts are formed at flat surfaces of said tube and said second parts are formed at bent parts in the cross-sectional shape of said tube.